| Work Ord June-12-13 9:2 | 26:24 AM | 3069 | | | Page 1 | | | | | | |
|---|-----------------------|------------------------------------|---|------------------------------------|--------------------------|------------|--------------|---------------|------------------|------------------|--------------------|
| Item ID: Revision ID: Item Name: | D2938-1 Saddle LH Out | . 206 | - | Accept | *N900 | 040 | 100 |)* s | etup Stai Sto | 1/1 | S1* S2* |
| Start Date: Required Date Reference: | 6/28/13 e: 6/28/13 | Start Qty: 4.00 Req'd Qty: 4.00 | *4* *4* | | Cust Item I Customer: | D: | | | | | |
| Approvals: | Process Plan | n: <u>fl_</u> | Date:/31/5/2 Date: | Tooling: SPC (Y/N): | | ate: | | R | tun Star Sto | 1/1 | R1* R2* |
| Sequence ID/ Work Center I | | Operation Description | | Set Up/ Run Hours | Tool ID | Tool# | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| Draw Nbr | Revi | ision Nbr | | , | | ~->3 | | · · · | , | | |
| D2938 | Rev | С | | | | | | | | | |
| *100 *100* HAAS 1 HAAS CNC vertice | al machine #1 | number are inspect as j | L MACHINING #1 art number and batch number programmed correctly 2-Materials attached D d visually inspect as per | achine Step No L of Fol | and batch | 13-08-2 | 0 | 4 | Ø | | <u> 13-8</u> -19 |
| *110 *110* Mill Conv Conventional Milli | ing Machine | CONVENTIONAL MI Memo Machine K | LLING MACHINE Leyway and inspect per attach | 0.00 0.00 ed dimension sheet | <i>M</i> 13- | -08-21 | | 4 | Ø | | |
| | | | | | | | | | | 43 , _ | |
| 120 | | QC1- Inspect dimensio | ns to dimension sheet | 0.00 | 44 | • | | <i>1</i> (| <i>b</i> | - *- | (1 12 5 -19 |
| *120* | | Мето | | 0.00 | S\$13-0 | 8-20 | | _4 | <u> 10</u> | | SL13-8-19 |

Quality Control

| DQA: | | Date: | | | | | | | | | | "AA DT |
|----------------------|----------|-------------|-------|----------|------------------------------|-----|----------|----------------------------|------|---------------|---------------|--------------------|
| 0.4.61 | | D-1 | | | WORK ORDER NON- | -C(| ONFO | RMANCE / UPDATE | | | | AEROSPACE |
| QA Closed: | | Date: | | | | | | | W | ork Order up | odate only | |
| Work Orde | er: | | | | DISPOSITION | | | AGAINS | T DE | PARTMENT | /PROCESS | |
| | | | | | Rework |] | | Skid-tube Crosstube | e 🗀 | 1 | Water Jet | Engineering |
| Part N | No. | | | | Scrap | | | Machining Small Fal | | Pro | d. Eng. Coor. | Quality |
| | | | | | Use-as-is | | | noforming Finishing | g | ={ | re/Packaging | Other |
| NCR N | No | | _ | | Suspected Unapproved | | | Large Fab Composite | 2 | | Supplier | 1 [1] |
| | | | | | | | | <u> </u> | | - | | |
| Root | | | | Desc | ription of work order update | Ī | Initial | Action | | Sign & | | |
| Cause | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Description | | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | |
| Doc/Data | | İ | | | | | | | | | | |
| Equip/Tooling | | ŀ | | | | | | | | | | |
| Handling/Pre | | | 1 | | | | | | | | | |
| Material | | | | | | | | | | | | |
| Operator | |] | | | | | | | | | | |
| Offset/Setup | | 1 | | | | | | | | | | |
| Process | | | | | | | | | | | | |
| Supplier Training | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | |
| | | | 1 | L | | FAI | ULT CAT | regory | | | L | <u> </u> |
| Landir | ng Gear | | | | General | | <u> </u> | | | - | | |
| | Bending | | | | Bend | | Folio/P | rogram · | | Outside Dim | ensions | Pressure/Forced |
| | Centre f | Not Concer | ntric | | BOM/Route | | Grain | • | | Over/Under | tolerance | Set-up |
| | Cracks | | | | Broken/Damage/Defect | | Hardwa | re | | Part Incorred | :t | Temperature/Cure |
| | Crimp/K | ink/Ripple | /Wave | | Burrs | | Inspecti | ion Incomplete/Unqualified | | Part Lost/Mi | ssing | Weld |
| | Cuffs | | | | Contamination | | Instruct | ions Incomplete/Unclear | | Part Moved | | Wrong Stock Pulled |
| | Crushin | 3 | | | Countersink | | Misalig | ned/off center | | Positioned V | /rong | _ |
| | Heat Tre | eat | | | Cut Too Short | | Mislabe | eled | | Power Loss/: | Surge | Other |
| | | on Strip in | Tube | | Drawing | L | Misread | 1 | | | | |
| | Marks/(| | | | Drill Holes | _ | Off-set | | | | | |
| | | Sequence | | <u> </u> | Finish | | • | Calibration | | <u></u> | | |
| | lWave/T | wist in Tuk | 10 | ŀ | Fit/Function | Ι. | Out of 9 | Contione | | | | |

| Work Orde June-12-13 9:20 | | 3069 | | *103 | ೧ 69* | | Pag | | | | | |
|--|------------------------|--|------------|-----------------------------|--------------------------|--------|--------------|---------------|------------------|------------------|-----------------|--|
| Revision 1D: | D2938-1 Saddle LH O | ut, 206 | | Accept | *N900 | 040 | 100 |)* s | etup Star Sto | I VI | S1* S2* | |
| Start Date: Required Date: Reference: | 6/28/13 6/28/13 | Start Qty: 4.00 Req'd Qty: 4.00 | *4* *4* | | Cust Item I Customer: | D: | | | | | - - | |
| Approvals: | Process Pl | an: | Date: | Tooling: SPC (Y/N): | | ate: | | ŀ | Run Stai Sto | " [X] | R1* R2* | |
| Sequence ID/ Work Center II 130 *130* QC Quality Control |) | Operation Description QC8- Inspect parts - sec | eond check | Set Up/ Run Hours 0.00 0.00 | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp | |

140

Chemical Conversion Coat per QSI005 4.1

0.00

140 HandFinish

Hand Finishing

Memo

0.00

16, 13.8-22

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150 Powdercoat

Powder Coating

Memo
START TIME:

START TIME:

OVEN TEMPERATURE:

32031

9-15

4xym/13/08/26

miablas

| DQA: | | Dat | e: | | _ | | | | | | | "DADT |
|---------------|-----------|---------------------------|---------|----------|---------------------------------------|----------|--------------------|---------------------------|----------|---------------------------------------|--|--------------------|
| QA Closed: | | Dat | e: | | WORK ORDER NON | -C(| ONFO | RMANCE / UPDATE | | ork Order up | odate only | AEROSPACE |
| | | | • | | DISPOSITION | | <u> </u> | ΔGA | | PARTMENT | | <u> </u> |
| Work Orde | er: | | | | | , | | | | , , , , , , , , , , , , , , , , , , , | ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,, | |
| | | | | | Rework | | | \vdash | stube | | Water Jet | Engineering |
| Part N | lo | | | | Scrap | | | *H | ll Fab | - | d. Eng. Coor. | Quality |
| | | | | | Use-as-is | | Thern | · H | shing | Rec/Stor | re/Packaging | Other |
| NCR N | No | | | | Suspected Unapproved | j | | Large Fab Comp | osite | J | Supplier | |
| Root | | | | Desc | ription of work order update | | Initial | Action | | Sign & | | |
| Cause | Da | te Ste | p Qty | / | or non-conformance | Ch | nief Eng | Description | | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | |
| Equip/Tooling | | | 1 | - | | ŀ | | | | | | |
| Handling/Pre | | | | | | | | | | | | |
| Material | | | | | | | | | | | | |
| Operator | | | | | • | | ψ. V. | | | | | |
| Offset/Setup | \square | | | | | | | | | | | |
| Process | | İ | | | | | | | | | | |
| Supplier | | | | | | | | | | | | |
| Training | | | | | |] | | | | | | |
| Fransport | | | | 1. | | 1 | | | | | | |
| Unapproved | | | | 1 | | <u> </u> | = | | | | | |
| | | | | | | FAI | ULT CAT | EGORY | | | | ···· |
| Landii | ng Gear | | | Γ | General | _ | 1 | | | 1 | _ | . |
| | Bend | - | | - | Bend | <u> </u> | | rogram | <u> </u> | Outside Dim | <u> </u> | Pressure/Forced |
| | _ | re Not Con | centric | <u> </u> | BOM/Route | <u> </u> | Grain | | <u> </u> | Over/Under | _ | Set-up |
| } | Crack | | | \vdash | Broken/Damage/Defect | | Hardwa | | | Part Incorrec | - | Temperature/Cure |
| | _ | p/Kink/Rip _l | pie/wav | e | Burrs | | 1 | on Incomplete/Unqualified | ' _ | Part Lost/Mi | ssing | Weld |
| | Cuffs | | | \vdash | Contamination | l—i | 4 | ions Incomplete/Unclear | | Part Moved | | Wrong Stock Pulled |
| | Crusi | Treat | | - | Countersink Cut Too Short | \vdash | 1 - | ned/off center | | Positioned W | | |
| | | rreat ection Strip | in Tubo | <u> </u> | 4 | ┝╌ | Mislabe | | L | Power Loss/S | ourge | Other |
| | | sction Strip s/Chatter | m rube | <u> </u> | Drawing Drill Holes | | Misread Off-set | I | | | | |
| | | ing Sequen | ra | - | Finish | - | 4 | Calibration | | | | <u> </u> |
| | | e/Twist in T | | \vdash | Fit/Function | _ | • | equence | | | | |
| _ | *** | C/ 1 4413 [11] | 300 | 1 | i i i i i i i i i i i i i i i i i i i | ı i | Logic Or 3 | requence | | | | |

| | Vork Order ID 103069 une-12-13 9:26:24 AM | | *103069* | | | | | | | | | Page 3 | | |
|---|---|------------------------------------|--------------------|----------------------|--------------------------|--------|--------------|---------------|--------------|---------------|------------------|-----------------|-----------------|--|
| Item ID: Revision ID: Item Name: | D2938-1 Saddle LH Ou | nt, 206 | | Accept | *N900 | 040 | 100 |)* s | Setup S | Start Stop | | S1* S2* | . .` | |
| Start Date: Required Date: Reference: | 6/28/13 6/28/13 | Start Qty: 4.00 Req'd Qty: 4.00 | *4* *4* | | Cust Item I Customer: | ID: | | | | | | | | |
| Approvals: | Process Pla | an: | Date: | Tooling: | D: | ate: | | R | | Start Stop | *N | R1* | | |
| | QC: | | Date: | SPC (Y/N): | D: | ate: | | | · · | stop | *N | R2* | | |
| Sequence ID/ Work Center II | D | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Rejec Qty | | Reject Iumber | Insp. Stamp | • | |
| *160 *160* QC Quality Control | | QC3- Inspect Part Finish Memo | | 0.00 | | | | 4 | | | | (DA: 05 13:0 | 08.26 | |
| 170 *17 0 * | | Identify as per dwg & Stoo | ck LocationST4 | 38 0.00 | | | | Цχ | | | | \sum_{i} |) | |
| Packaging Packaging | | Memo | | 0.00 | | | | ح دی۔ | | | | 13-8 | 7 | |
| *180 | | QC21- Final Inspection - | Work Order Release | 0.00 | | | | | | 13 | 18/2 | 29 H | } | |
| QC | | Memo | | 0.00 | | | | - | | 1 | | -11/ | | |

Quality Control

\$13813

| DQA: | | _ Date: | | | . WORK OBDED NON | c | NIEOI | DNAANCE / HDDATE | | | | `DART |
|---------------|----------------|-------------|------------|----------|------------------------------|----------|----------|---|----------|------------------|--------------|---------------------------|
| QA Closed: | _ | Date: | | | WORK ORDER NON- | | JINFOI | RIVIANCE / OPDATE | W | ork Order u | odate only | AEROSPACE |
| Work Orde | r· | | | | DISPOSITION | | | AGAINST | r DE | PARTMENT | /PROCESS | |
| Part N | o | | | _ | Rework Scrap Use-as-is | - 1 | | Skid-tube Crosstube Machining Small Fab noforming Finishing | | Prod. Eng. Coor. | | Engineering Quality Other |
| NCR N | lo | | | | Suspected Unapproved |] | | Large Fab Composite | <u>:</u> | | Supplier | |
| Root | | | | Desc | ription of work order update | 1 | nitial | Action | • | Sign & | | |
| Cause | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Description | | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | |
| Handling/Pre | .,, | | | | | | | | | | | |
| laterial ද් |) | | | | | | | | | | | |
| Operator - | <u>-</u> | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | |
| Process | | | | | | | | | | | i | |
| Supplier | | | | | | | | | | | | |
| Training | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | |
| Unapproved | | <u> </u> | <u>i i</u> | | | | | rccopy | | | | |
| Landin | g Gear | | | | General | FAI | OLI CA | regory | | | | |
| Lantin | Bending | | | | Bend | | lealia/e | Program | _ | Outside Dim | _ | Pressure/Forced |
| - | | ot Concer | atric | - | BOM/Route | <u> </u> | Grain | TOGIANI | \vdash | Over/Under | <u> </u> | Set-up |
| - | Cracks | ot concer | ICIIC | \vdash | Broken/Damage/Defect | \vdash | Hardwa | *** | \vdash | Part Incorred | ├ | Temperature/Cure |
| - | - | nk/Ripple | Alavo | - | Burrs | H | İ | ion Incomplete/Unqualified | \vdash | Part Lost/Mi | - | Weld |
| - | Cuffs | iik) Nippie | / wave | \vdash | Contamination | | 1 | tions Incomplete/Unclear | \vdash | Part Moved | 221118 | Wrong Stock Pulled |
| } | Crushing | | | | Countersink | \vdash | 1 | ned/off center | \vdash | Positioned V | L | |
| } | Heat Tre | | | | Cut Too Short | | Mislabe | | \vdash | Power Loss/ | | Other |
| } | | on Strip in | Tuho | <u> </u> | Drawing | \vdash | Misread | | | Trower rossy | onige [| Torrier |
| } | Marks/Cl | | 1000 | \vdash | Drill Holes | - | Off-set | , | | | | |
| } | | Sequence | | - | Finish | | ł | Calibration | | | | |
| } | | vist in Tub | | - | Fit/Function | \vdash | ł | Seguence | | | | |
| | | | | | | | | | | | | |

Picklist Print

June-12-13 9:26:23 AM

Work Order ID:

103069

Parent Item:

D2938-1

Parent Item Name:

Saddle LH Out, 206

Start Date: 6/28/13

Required Date: 6/28/13

Page 1

Start Qty: 4.00

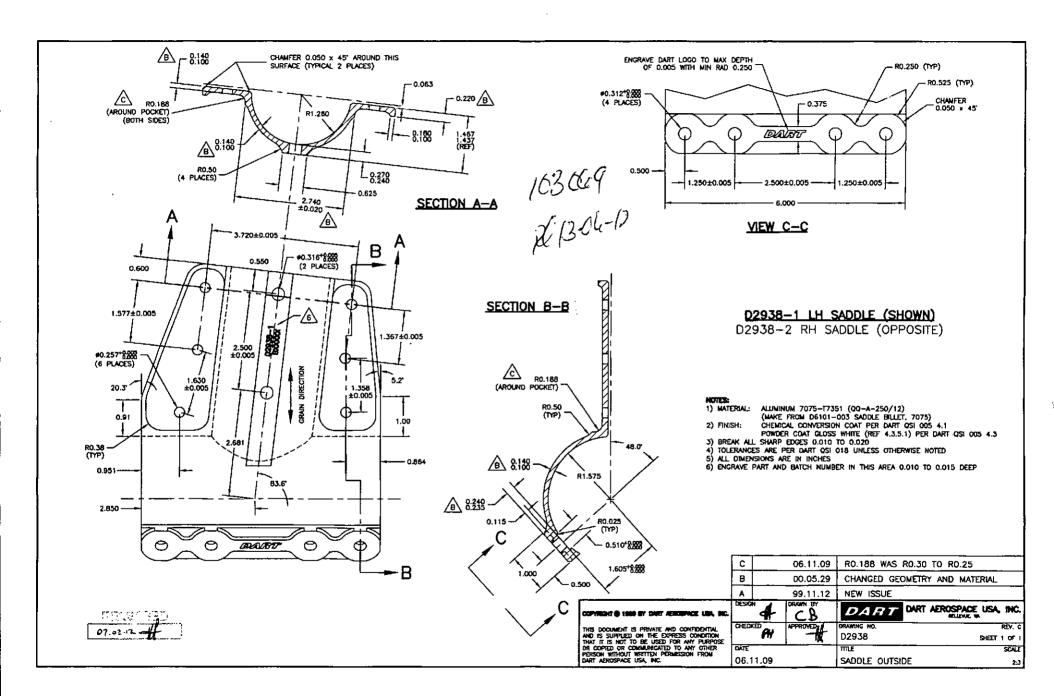
Required Qty: 4.00

Comments:

IPP: B 00.06.26 New DWG rev (mpp 2069)EC IPP Rev: C As per Rev C 07-03-19 ILM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|---------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-003 | | Manufactured | No | | | 100 | Each | 48.0000 | 1 | 4 | | | |
| Saddle Billet, 7075 | | | | | | | | | | | | -8-19 | |
| | | | | <u>Location</u> | | Loc Oty | Lo | oc Code | | | | | |
| | | | | MAT042 | | 2 | | | | | | | |
| | | | | 9841 | 7 | 2 | | | | | | | |
| | | | | MAT045 | | 46 | | | | | | | |
| | | | | 9756 | 3 | 46 | | | | | | | |
| | | | | 103 | 3.592 | | | | Н | | | | |

| DQA: | | | Date: | | | | | | | | | | DART |
|---------------|---------------------------------|------------|------------|----------|------|-----------------------------------|----------|----------|------------------------|------------------------|--------------|--------------------------|--------------------|
| QA Closed: | | | Date: | | | WORK ORDER NON- | -CC | ONFOI | RMANCE / U | | Work Order u | pdate only | AEROSPACE |
| Marile Onda | | | | | ļ | DISPOSITION | | | | AGAINST [| EPARTMENT | /PROCESS | |
| Work Orde | er: | | | | | Rework | 1 | | Skid-tube | Crosstube | 7 | Water Jet | Engineering |
| Part N | No | | | | | Scrap | | | Machining | Small Fab | Pro | d. Eng. Coor. | Quality |
| NCR N | - No | | | | | Use-as-is Suspected Unapproved | | ·Thern | noforming Large Fab | Finishing Composite | Rec/Sto | re/Packaging Supplier | Other |
| Root | | | | | Desc | ription of work order update | l I | nitial | Act | tion | Sign & | <u> </u> | |
| Cause | 1 | Date | Step | Qty | 0000 | or non-conformance | i i | ief Eng | | ription | Date | Verification | QC Inspector |
| Design | | | | | | | <u> </u> | | | | | | |
| Doc/Data | П | | | | | | | | | | | | |
| Equip/Tooling | П | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | |
| Material | \Box | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | |
| Offset/Setup | П | | |] | | | | | | | | | |
| Process | П | | | | | | l | | | | | | |
| Supplier | П | | | | | - | | | | • | | | |
| Training | П | | | | | | 1 | | | | | | , |
| Transport | | | 1 | | | | | | | | | | |
| Unapproved | П | | | | | | | | | | | | |
| | | | | <u> </u> | | | FA | ULT CA | EGORY | | | | |
| Landi | ng G | ear | | | | General | | | · | | · · · | | |
| | | Bending | | | | Bend | | Folio/F | rogram | ſ | Outside Din | nensions | Pressure/Forced |
| | П | Centre No | ot Concer | ntric | | BOM/Route | | Grain | | Γ | Over/Under | tolerance | Set-up |
| | П | Cracks | | | | Broken/Damage/Defect | | Hardwa | re | Γ | Part Incorre | ct | Temperature/Cure |
| | П | Crimp/Kir | nk/Ripple | /Wave | | Burrs | | Inspect | ion Incomplete/U | ngualified | Part Lost/M | issing | Weld |
| | - | Cuffs | | | | Contamination | | Instruct | ions Incomplete/U | Jnclear | Part Moved | | Wrong Stock Pulled |
| | \Box | Crushing | | | | Countersink | | | ned/off center | | Positioned \ | Wrong | _ |
| | _ | Heat Trea | at | | | Cut Too Short | | Mislabe | | | Power Loss, | /Surge | Other |
| | \Box | Inspection | n Strip in | Tube | | Drawing | | Misread | d | - | | _ | |
| | ${f m m m m m m m m m m m m m $ | Marks/Ch | • | | | Drill Holes | Г | Off-set | | | | | |
| | ${f m H}$ | Turning S | | | | Finish | | Out of | Calibration | | | | |
| | П | Wave/Tw | ist in Tub | ъе | | Fit/Function | | Out of | Sequence | | | | |



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Robert Co

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| DART AEROSPACE LTD | Work Order: | 103069 |
|--|--------------|-------------|
| Description: 206 Saddle, Outboard, Left side | Part Number: | D2938-1 |
| Inspection Dwg: D2938 Rev. C | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

| Dim Min Max Go/No Go Gauge 1 2 3 4 By A 0.100 0.140 129 129 128 128 B 0.100 0.140 129 128 128 C 0.100 0.140 116 116 116 116 D 0.210 0.230 -220 -220 120 E 1.245 1.255 1250 1250 1250 1250 F 1.245 1.255 1250 1250 1250 1250 G 2.495 2.505 2.500 2.500 2.500 2.500 H 0.510 0.515 1.572 1.572 1.574 1.574 J 2.495 2.505 2.500 2.500 2.500 2.500 K 0.257 0.262 2.58 2.58 2.58 2.58 N 0.100 0.140 -233 125 125 124 N 0.100 0.140 -233 125 125 124 1.555 1.256 1.576 1.576 1.576 2.495 2.505 2.500 2.500 2.500 2.500 K 0.257 0.262 2.58 2.58 2.58 2.58 N 0.100 0.140 -233 125 124 N 0.100 0.140 -233 125 125 124 D 125 124 125 124 125 124 125 124 D 126 128 | |
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| B 0.100 0.140 | Date |
| B 0.100 0.140 | |
| C 0.100 0.140 -116 | |
| D 0.210 0.230 | |
| F 1.245 1.255 | |
| F 1.245 1.255 | |
| G 2.495 2.505 Q.500 Q.500 Q.500 Q.500 H 0.510 0.515 | _ |
| H 0.510 0.515 .512 .512 .512 .512 .512 .512 .512 | |
| 1.572 1.582 1.574 1.574 1.577 1.57 | |
| J 2.495 2.505 Q.500 Q.500 Q.500 Q.500 K 0.257 0.262 Q.58 Q.58 Q.58 Q.58 L 0.312 0.317 Q.544 Q | |
| K 0.257 0.262 258 258 258 258 L 0.312 0.317 314 314 314 314 M 0.235 0.240 238 238 238 238 N 0.100 0.140 233 123 125 124 | , |
| L 0.312 0.317 .314 .314 .314 .314 .314 .314 .314 .314 | |
| M 0.235 0.240 238 .238 .238 .238 .238 N 0.100 0.140 233 123 125 .124 | |
| N 0.100 0.140 -23 125 .124 | |
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| 0 0.540 0.560 549 550 546 548 | |
| P 0.490 0.510 .497 .498 .498 .500 | |
| 0 3.715 3.725 3.420 3.420 3.420 3.420 | |
| F 2.720 2.760 2.740 2.740 2.740 2.740 | |
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| S 0.240 0.270 | · · · · · · · · · · · · · · · · · · · |
| U 1.625 1.635 1.636 1.630 1.630 1.630 | |
| V 1.362 1.372 1.367 1.367 1.367 | |
| W 0.316 0.321 316 316 316 316 | |
| X 1.250 1.270 / 260 1.260 1.259 1.260 | |
| Y 1.565 1.585 / 575 1.573 1.5735 | |
| Z 0.178 0.198 - 188 - 188 - 188 | |
| AA | |
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| AĎ | - |
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| Accept/Reject | ············ |

Measured by: | S| | Audited by | 44 |
Date: |3-X-|9| |13-08-20 | Date: |13-08-22

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| Α | | New Issue | RF | |
| ∏B` | 02.12.12 | Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF | 1 |
| С | 67.03.21 | Revised per drawing revision C | KJ/JLM | Cidl |
| | ·- | | | 7,007 |

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